

SPLIT

Date: Monday, 9/11/2006 3:43:53 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 02.250 SUPPORT
Job Number	: 28482		
Estimate Number	: 11057		
P.O. Number	: <i>N/A</i>	Part Number	: D28911
This Issue	: 9/11/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2891 REV A1
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28388	Drawing Revision	: A1
		Material	: <i>N/A</i>
		Due Date	: 9/30/2006
Written By	: <i>[Signature]</i>	Qty:	<i>8</i> Um: Each
Checked & Approved By	: <i>[Signature] 06 09.12</i>		
Comment	: Est. C 02.11.26 Added P/O KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *2008*

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

2.0	D6104003	17-4 SS Roundbar 3.25"OD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Support 2.25 dia

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

5.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Number: 28482

Part Number: D28911

umber:



Seq. #: Machine Or Operation: Description :

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046
Tumble & Deburr

En 06/10/13 x4

mf 06/10/06

4

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



En 06/10/13 x4

mf 06/10/06

4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD / 3.2

06/10/06

4

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

HC 06 10 16

(4)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/10/17

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 166

LB 06/10/17

(4)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

(4)

Job Completion



U 06/10/18

Crucible
Specialty Metals
A Division of Crucible Materials Corporation

P.O. BOX 977
SYRACUSE
NEW YORK 13201

CERTIFICATE OF TEST

COPPER & BRASS SALES INC
ATTN: ACCOUNTS PAYABLE
22355 WEST ELEVEN MILE RD
SOUTHFIELD MI 48034

S
H
I
P

T
O

COPPER & BRASS SALES
6355 E. DAVISON
DETROIT, MICHIGAN
48212-1499

OUR ORDER NO.
F5-12987-6-C

DATE
08/09/06

CUSTOMER ORDER # & DATE
CK4179

CUSTOMER REQ. #

DISTRICT

B PARSONS

SHIPPED
FROM

SYRACUSE

DESCRIPTION OF MATERIAL

SIZE
3.250 RD

CRU 17CR-ANI T&B ANN (F/N 408406-7)
ASTM-A564-04 TYPE 630 AMS-56430 AMS-2303E
UFARS 252.225.7014 & 225.7002-3 (B)(1) COMPLIANT

CHEMICAL ANALYSIS

HEAT NO	C	HN	P	S	SI	NI	CR	MO	CU	CB	TA
A17799	.041	.55	.027	.020	.55	4.30	15.40	.090	3.16	.25	.007

MECHANICAL PROPERTIES

QUANTITY	HEAT NO.	TENSILE PSI	YLD.2XPSI	XENONG4D	RED/AREAX	HARDNESS BRIN 355
1835	A17799					
CAPABILITY PHYSICALS AFTER 900 DEG. F. - 1 HR. AIRCOOL:						
		199,990	175,630	16.1	53.3	BRIN 401

MACRO TEST OK
FERRITE 5 %
MAGNAFLUX F/S = 0/0

MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT
NO WELD REPAIR PERFORMED
MATERIAL MELTED IN U.S.A.

THANK YOU FOR SELECTING A QUALITY PRODUCT
MANUFACTURED BY THE EMPLOYEES OF CRUCIBLE SPECIALTY METALS

THE ABOVE MATERIAL WAS MANUFACTURED AND TESTED IN ACCORDANCE
WITH ABOVE SPECIFICATIONS AND IS IN CONFORMANCE WITH THE
SPECIFICATION REQUIREMENTS
CRUCIBLE MATERIALS CORPORATION
ACTING BY AUTHORITY OF ITS SPECIALTY METALS DIVISION

SWORN TO AND SUBSCRIBED BEFORE ME THIS

DAY OF , 20

DART AEROSPACE LTD	Work Order: 28482
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	45	20	87	48		
Lathe Section									
A	2.274	2.279	2.279	2.279	2.279	2.278	2.278		
B	3.702	3.722		3.712	3.712	3.714	3.714		
C	2.564	2.584		2.576	2.576	2.576	2.576		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.095	.100	.100	.100		
F	2.464	2.484		2.476	2.476	2.476	2.476		
G	2.029	2.049		2.035	2.035	2.035	2.035		
H	2.964	2.984		2.976	2.976	2.975	2.975		
I	0.913	0.933		.923	.923	.923	.923		
J	0.022	0.042		.032	.032	.032	.032		
K	0.090	0.110		.098	.098	.098	.098		
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AB	0.240	0.260		0.244	0.249	0.241	0.244		
AC	0.115	0.150		0.128	0.128	0.122	0.122		
AD	0.040	0.060		0.051	0.044	0.045	0.056		
AE	0.010	0.020		0.015	0.015	0.015	0.015		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.290	0.310		0.297	0.295	0.301	0.301		
AH	0.115	0.150		0.134	0.138	0.136	0.131		
AI	0.454	0.474		0.468	0.466	0.467	0.462		
AJ	2.779	2.789		2.780	2.780	2.781	2.779		
AK	0.240	0.260		0.250	0.250	0.250	0.250		
AL	1.002	1.042		1.042	1.042	1.042			
AM	0.053	0.073		0.063	0.063	0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
AO	1.663	1.683		1.680	1.679	1.681	1.677		
AP	0.053	0.073		0.063	0.063	0.062	0.063		
AQ	0.022	0.042		0.030	0.030	0.030	0.030		
AR									
AS									
Accept/Reject									

Measured by:	BC/MS/EP
Date:	06/10/13

Audited by:	JD
Date:	06/10/13

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	#